

Wire and Welding products

HAYNES
Wire Company



HAYNES[®] 200 RTW[®]

Product Description:

HAYNES[®] 200 RTW[®] is used for the gas metal arc, gas tungsten arc and submerged arc welding of a variety of cast iron grades including gray, malleable and ductile. The weld deposits are easily machinable and can be deposited using a variety of processes. HAYNES[®] 200 grade is equivalent to filler metal 99 grades and can be used to weld cast iron materials to a variety of carbon steels. The RTW[®] finish on the spooled wire promotes smooth feeding through welding equipment and reduced tip wear in contact tips.

Specifications:

AWS A5.15 ERNi-CI
ASME SFA5.15 ERNi-CI

UNS N02215

Weld Deposit Chemistry:

Ni.....	99.0 min.	Si.....	0.35 max.
Fe.....	0.40 max.	S.....	0.01 max.
Cu.....	0.25 max.	C.....	0.015 max.
Mn.....	0.35 max.	Other.....	1.00 max.

Minimum Mechanical Properties:

Tensile (psi)	71,000
Mpa	490
Elongation (%)	12

Available Product Forms:

Diameter in	0.031	0.035	0.039	0.045	0.047	0.062	0.078	0.093	0.125
Diameter mm	0.8	0.9	1.0	1.1	1.2	1.6	2.0	2.4	3.2

Filler metals are available in spools and in cut lengths from the above diameters.
Straight lengths are available in 36" lengths.

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HAYNES[®] 200 Reduced Tip Wear (RTW[®])